

PRELIMINARY ISSUE

Work Order ID 53211

October 26, 2009 2:18:03 PM

Page 1

Item ID: D4011-3

Accept

Revision ID: A-PRELIM 06.10.26

Item Name: Clamp, Long

Start Date: 10/26/09 Start Qty: 12.00

Required Date: 10/28/09 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4011

A-PRELIM

100

0.00

Purchasing

Memo

0.00

Purchasing

Issue P/O:

Manufacture as per Dwg D4011

Supplier: G.F.I.

Material release note is required

805

surzll Fzb

Bend per Juncy

→ QC2 B 9-10-27

→ QC8 ⇒ 8 or 10/27 10/10/27

B 9-10-27

Wk 12 only Lc

(16)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

QC5 ⇒ 8 or 10/29

10/10/29

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Work Order ID 53211

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Page 2

Item ID: D4011-3

Accept



Setup Start



Revision ID: A-PRELIM

Stop



Item Name: Clamp, Long

Start Date: 10/26/09 Start Qty: 12.00



Cust Item ID:

Required Date: 10/28/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

USE FOR TESTING.
SCRAP REMAINING PARTS.
09.11.22 10/12/01

N/A.

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

[Signature] Prototype only
09.10.30

W 09.12.16
R00324A DEC
POSITIVE RECALL
EFFECTIVE
RELEASED
AUTH
DATE
09.11.22

Picklist Print

Page 1

October 26, 2009 2:17:53 PM

Work Order ID: 53211



Parent Item: D4011-3

Parent Item Name: Clamp, Long

Start Date: 10/26/09

Required Date: 10/28/09

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	219.8531	0.8072	1.0762		



304/316 Sheet .063



189-10-27

Warehouse Location

Loc Qty

Loc Code

Main Warehouse

MAT

219.8530737

106860

16.018

111924

25.1689737

112442

43.1663

112567

7.4998

112885

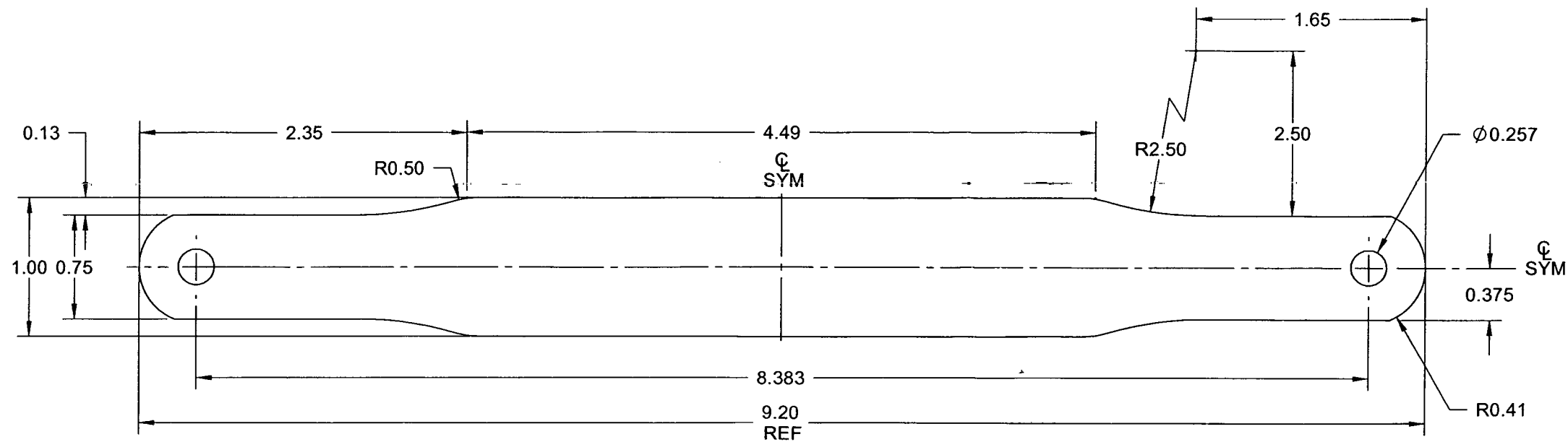
128

112567

8 7 6 5 4 3 2 1

D

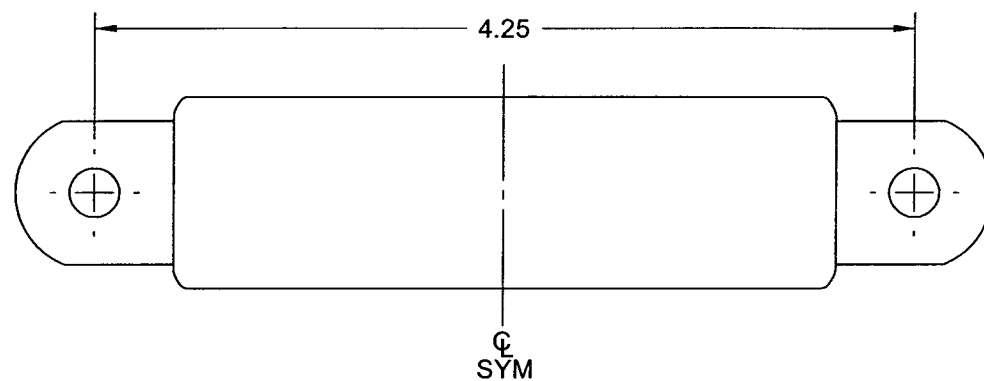
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D4011-3F CLAMP FLAT PATTERN, LONG

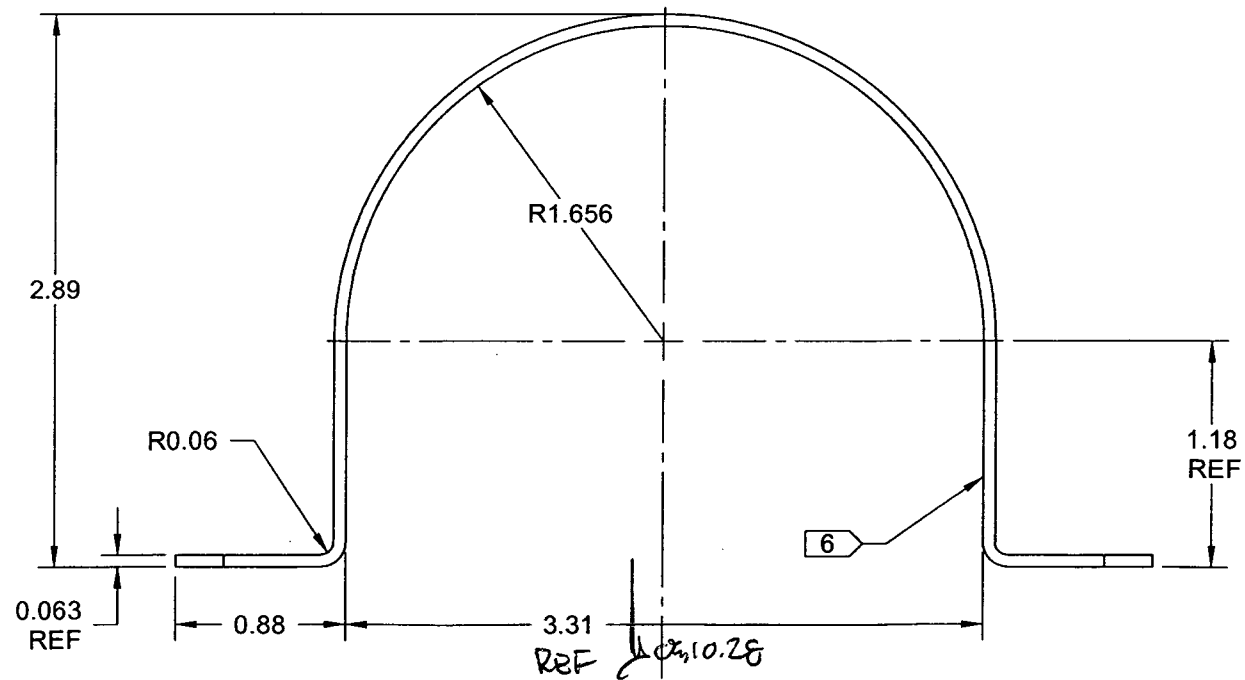
C

C



B

B



D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

PRELIMINARY ISSUE

06.10.26

PER ECN#09-695P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4011	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	09.10.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

Receiving Report

Date: 9/9/02

Batch No: M112567

Supplier: MAGNA

Dart P/O: 10312

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ 8 N/A ☐
 Work Order 09109102 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061	TGB-200x0400	40	0	0	40	
M6061T	30181x0400	40	0	0	40	
M6061T	TGB1-200x0400	40	0	0	40	

M6061T 6R0620

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

09/09/02

RCP 10312

CV

Location

M 3095126A

69 0 0 69



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10312

Purchase Order Date 9/01/09

PO Print Date 9/01/09

Page Number 4 of 4

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone

800 363 6646

Vendor Fax

514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

16	✓ M304S16GA	304/316 Sheet .063	9/04/09	✓ 96 92.00	Yours ppd	\$5.0000	\$460.00
			Yes	sf			

Special Inst: AS ABOVE

17	✓ M304S20GA	304/316 .040 Sheet	9/04/09	✓ 192.00		\$3.9062	\$749.99
			Yes	sf			

Special Inst: AS ABOVE

PO Total: \$5,356.49

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 9/01/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

MILL TEST REPORT

TA CHEN INTERNATIONAL CORPORATION

www.tachen.com

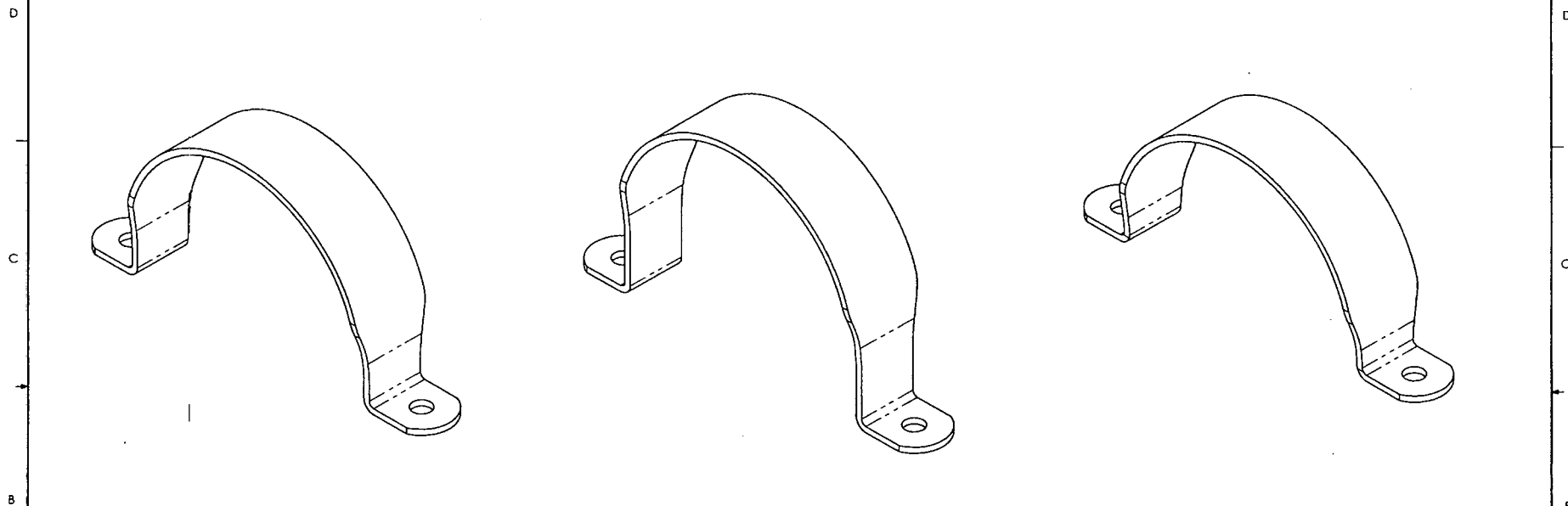
This MTR contains 1 page (Page: 1)

MTR#: T1CL2121 Customer#: MAGDOR PO#: P006327 SO#: PE6925
 Item#: 16GA48963042B Bundle#: KA80261180E10H5 Heat#: A2800233

Shanxi Taigang Stainless Steel CO.,LTD Member of Taiyuan Iron and Steel (Group) Co.,LTD		MILL TEST CERTIFICATE										
NO.2 jiancaoping,Taiyuan,Shanxi,P.R.China		CERTIFICATE NO.	T08-692B									
TEL: (0351)3013328 FAX: (0351)3017816		MATERIAL	AISI304 NO. 2B FINISH									
http://www.tisco.com.cn		SPECIFICATION	ASTM A240-04/A480-04, ASME SA240/A480 ASTM A666, AMS 5513/5511									
E-mail: tgbxg@tisco.com.cn		L/C No.										
CUSTOMER		CONTRACT NO.	DATE OF ISSUE									
Ta Chen International, Inc.		L22628	20080401									
Product	Melting furnace	Inspectors stamp	Mark of the Manufacturer									
SHEET	E+VOD		Shanxi Taiyuan Stainless Steel Co.,Ltd									
NO.	Heat No.	Coil No.	Batch No.	Quantity	Dimensions (inch)	Weight(Pound)						
43	C3706216	KA71272980F00H3	78253308	1	16GA x 48" x 120	4535						
44	C3706216	KA71272980F00H2	78253309	1	16GA x 48" x 120	4546						
45	A2800233	KA80261180E10H5	78255632	1	16GA x 48" x 96	4270						
46	A2800233	KA80261180E20H1	78255634	1	16GA x 48" x 96	4259						
47	A2800233	KA80261180E20H2	78255636	1	16GA x 48" x 96	3874						
48	A2800233	KA80261180E20H3	78255638	1	16GA x 48" x 96	4348						
49	A2800233	KA80261180E20H4	78255640	1	16GA x 48" x 96	3896						
Chemical Composition												
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	N	Mo	Ti
C3706216	0.055	0.560	1.090	0.028	0.001	18.190	8.160	0.160		0.066	0.090	
C3706216	0.055	0.560	1.090	0.028	0.001	18.190	8.160	0.160		0.066	0.090	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
Mechanical Properties (Test temperature :20°C)												
Test No.	Tensile R _m N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation		Corrosion Tests	Hardness					
				A5 (%)	A50(%)		HRB	HV	HRC			
78253308-T	660	305			54		91.5-90.5					
78253309-T	660	305			54		91.5-90.5					
78255632-T	645	299			51		87.5-88.0					
78255634-T	645	299			51		87.5-88.0					
78255636-T	645	299			51		87.5-88.0					
78255638-T	645	299			51		87.5-88.0					
78255640-T	645	299			51		87.5-88.0					
SPECTROMETER SORTING TEST: OK												
EN 10204-3.1B												
Mercury Free												
Place: Taiyuan												
Work Inspector: 李忠新												

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8 7 6 5 4 3 2 1



D4011-1 CLAMP, SHORT

D4011-3 CLAMP, LONG

D4011-5 CLAMP, SHORT (OEM)

53211

RELEASED
2009-11-24
MP

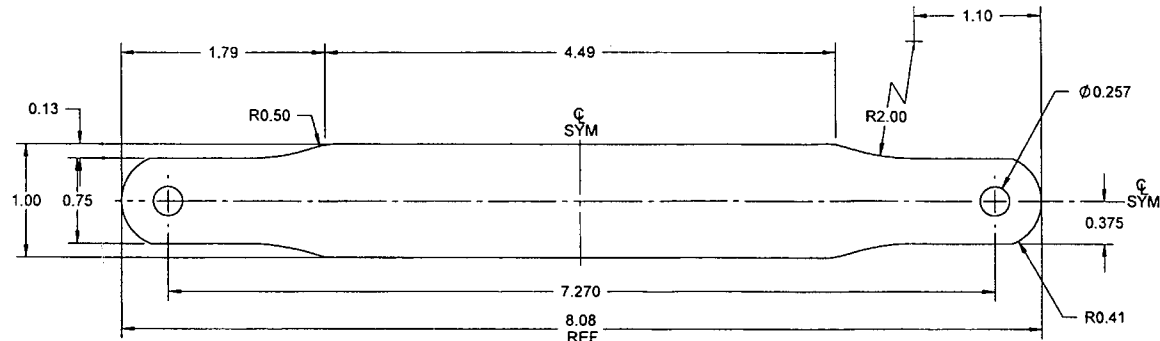
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

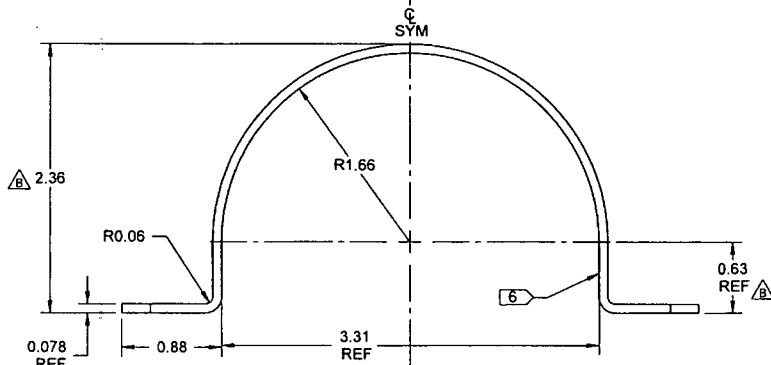
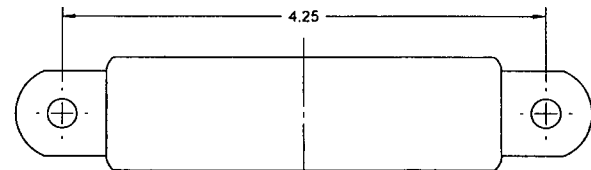
B	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES		MB	09.11.11
A	NEW ISSUE		MB	09.10.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD			
DRAWN	HAWKESBURY, ONTARIO, CANADA			
CHECKED	AS	DRAWING NO.	REV. B	
MFG. APPR.	NS	D4011	SHEET 1 OF 4	
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4011-1F CLAMP, SHORT FLAT PATTERN



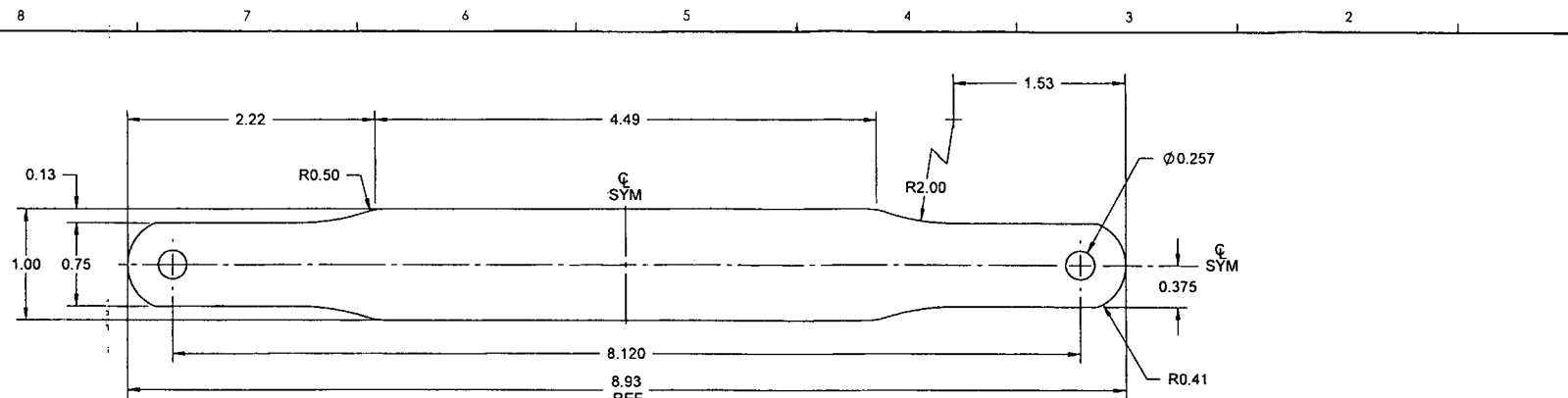
**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

53211

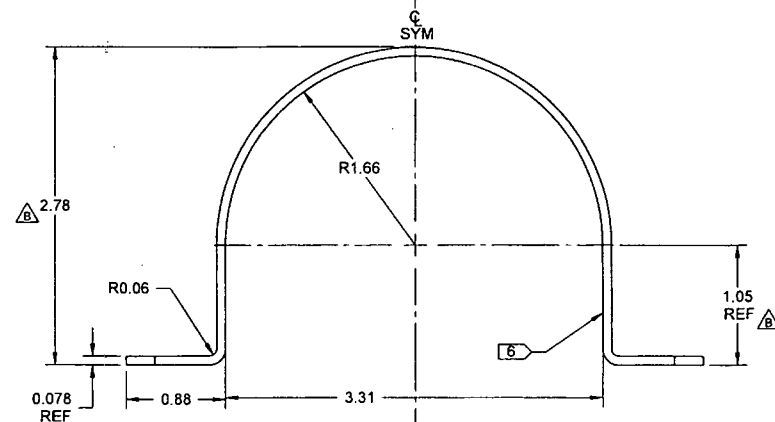
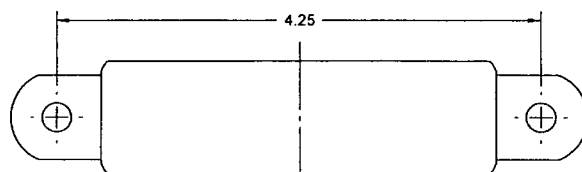
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2009-11-24
MJD

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MFG. APPR.		D4011	SHEET 2 OF 4
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8 7 6 5 4 3 2 1



D4011-3F CLAMP FLAT PATTERN, LONG

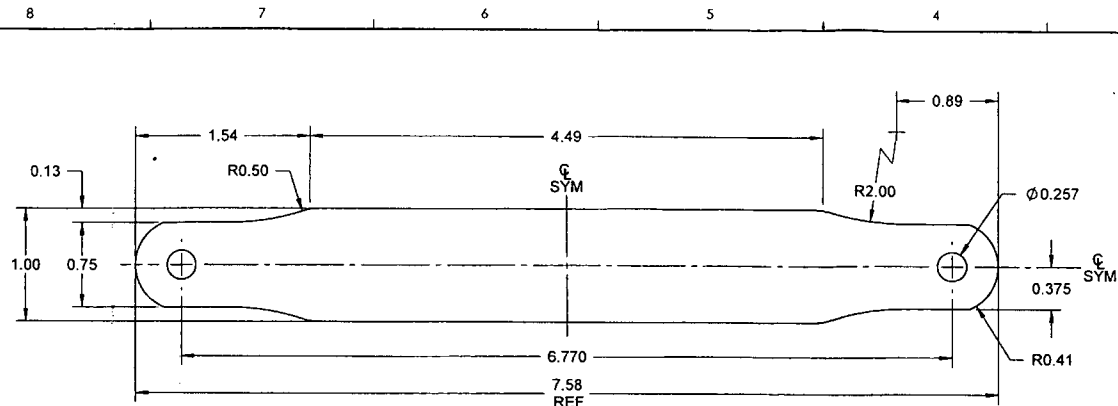


D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

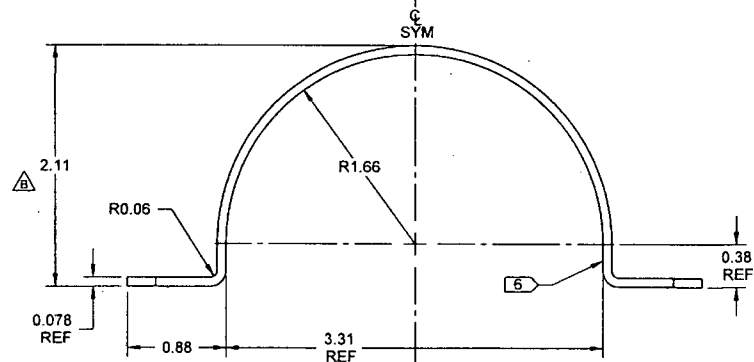
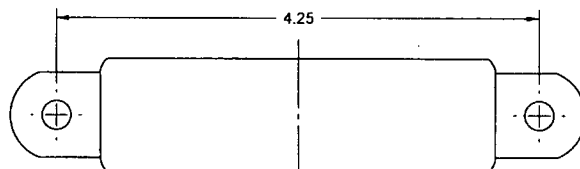
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2009-11-24
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APPROVED		TITLE	SCALE
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D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

53211

RELEASED
2009-11-24
MP

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	NS	D4011	SHEET 4 OF 4
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DE APPR.	SH	CLAMP	NTS
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